

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____						

Work Order ID 159842

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Item ID: D066-1003-011L08

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: R66 Cabin Floor Protector - Clear

Start Date: 5/2/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/4/2017 Req'd Qty: 1.00

1

Customer:

Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D066-1003-011L08 Location: <u>EG117</u> <i>fs 117</i>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

DAS
27
9-89

APR 28 2017

DAS
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9-89

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DAS
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 159842

159842

Parent Item: D066-1003-011L08

D066-1003-011L08

Parent Item Name: R66 Cabin Floor Protector - Clear

Start Date: 5/2/2017

Required Date: 5/4/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.02.05 NEW ISSUE DD VERF:JLM IPP Rev. B
14/07/02 Parts list updated. DL IPP REV:C 15.02.1 AS
PER IIN REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3580-3 *D3580-3* Joggle Bracket		Manufactured	No			110	Each	30.0000	6	6		APR 27 2017	DAS 6 27 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST040		30							
				136061		5							
				145423		25							
MS21059L3 *MS21059L3* Nut Plate		Purchased	No			110	Each	120.0000	6	6		APR 27 2017	DAS 6 27 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		50							
				M137075		50							
				ST301		70							
				M137164		70							
D4941-1L08 *D4941-1L08* Floor Protector, Fwd LH, (Clear)		Manufactured	No			110	Each	0.0000	1	1		APR 27 2017	DAS 6 27 9-89
D4941-2L08 *D4941-2L08* Floor Protector, Fwd RH, (Clear)		Manufactured	No			110	Each	0.0000	1	1		APR 27 2017	DAS 6 27 9-89
D4941-3L08 *D4941-3L08* Floor Protector, Aft LH, (Clear)		Manufactured	No			110	Each	0.0000	1	1		APR 27 2017	DAS 6 27 9-89

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Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 159842

159842

Parent Item: D066-1003-011L08

D066-1003-011L08

Parent Item Name: R66 Cabin Floor Protector - Clear

Start Date: 5/2/2017

Required Date: 5/4/2017

Start Qty: 1.00

Required Qty: 1.00

D4941-4L08 Manufactured No

110 Each

0.0000

1 1

D4941-4L08

Floor Protector, Aft RH, (Clear)

AN525-10R8

Purchased No

110 Each

297.0000

6 6

AN525-10R8

Screw

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Location

Loc Qty

Loc Code

ST329

297

m135058

297

110 Each

8,212.000

12 12

MS20426AD3-4

Purchased No

MS20426AD3-4

RIVET

DAS
38
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Location

Loc Qty

Loc Code

GA

6474

m134294

1921

m136444

4553

ST312

1738

m134294

1738

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APR 27 2017

APR 27 2017

APR 27 2017

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

4.0 WEIGHT AND BALANCE

The following is the weight increase associated with the D066-1003-XXX kits. Be sure to subtract the weight of any parts removed.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D066-1003-011L02 Cabin Floor Protector (Black Lexan Sheet)	6.7 lb 3.0 kg	0.10 in 0.00 m	0.67 in-lb 0.00 m-kg	43.72 in 1.11m	293 in-lb 3.33 m-kg
D066-1003-011L08 Cabin Floor Protector (Clear Lexan Sheet)	6.7 lb 3.0 kg	0.10 in 0.00 m	0.67 in-lb 0.00 m-kg	43.72 in 1.11m	293 in-lb 3.33 m-kg
D066-1003-013 Baggage Compartment Protectors	16.5 lb 7.5 kg	3.29 in 0.08 m	54 in-lb 0.60 m-kg	104.35 in 2.65 m	1721 in-lb 19.88 m-kg

5.0 PARTS LIST

Qty -011 L02	Qty -011 L08	Qty -013	Part Number	Description
X			D066-1003-011L02	CABIN FLOOR PROTECTORS (BLACK)
	X		D066-1003-011L08	CABIN FLOOR PROTECTORS (CLEAR)
		X	D066-1003-013	BAGGAGE COMPARTMENT PROTECTORS
1			D4941-1L02	FLOOR PROTECTOR, FWD LH
	1		D4941-1L08	FLOOR PROTECTOR, FWD LH
1			D4941-2 L02	FLOOR PROTECTOR, FWD RH
	1		D4941-2 L08	FLOOR PROTECTOR, FWD RH
1			D4941-3 L02	FLOOR PROTECTOR, AFT LH
	1		D4941-3 L08	FLOOR PROTECTOR, AFT LH
1			D4941-4 L02	FLOOR PROTECTOR, AFT RH
	1		D4941-4 L08	FLOOR PROTECTOR, AFT RH
		1	D4942-1	FLOOR PROTECTOR
		1	D4942-3	FORWARD WALL PROTECTOR
		1	D4942-7	LH WALL PROTECTOR
		1	D4942-9	DOOR PROTECTOR
		2	D4967-1	BRACKET
6	6		D3580-3	JOGGLE BRACKET
		3	D3580-5	JOGGLE BRACKET
		1	D5119-1	PLACARD
		1	D5120-1	PLACARD
6	6		AN525-10R8	SCREW
		10	AN525-10R9	SCREW
		8	CS62-1032-8CR	STUD, CLICK BOND
		3	AN970-3	WASHER
		8	MS21042-3	NUT, SELF LOCKING
		5	CB 200	3.5G ACRYLIC ADHESIVE
6	6	10	MS21059L3	NUTPLATE
12	12	20	MS20426AD3-4	RIVET